

Split

Work Order ID 68216-1



Page 1

Friday, April 08, 2011 3:00:04 PM

Item ID: D3955-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 4/8/2011

Start Qty: 5



Cust Item ID:

Required Date: 4/12/2011

Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-8

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3955

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B1-4-11

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

H31-4-11

# Work Order ID 68216

Friday, April 08, 2011 3:00:04 PM



Page 2

Item ID: D3955-041

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Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 4/8/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

ml 11 04 12 (8)

130



Small Fab

Small Fab

Memo

1- C'sink holes as per dwg

2- Deburr if necessary

0.00

0.00

Ep 04/15 (8)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

ml 11 04 15 (8)

**Work Order ID 68216**

Friday, April 08, 2011 3:00:04 PM



Page 3

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Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 4/8/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

8 p 11-4-18

160



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

8 BR 11-4-18

170



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

8 BR 04/19 (5)

**Work Order ID 68216**

Friday, April 08, 2011 3:00:04 PM



Page 4

Item ID: D3955-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler Assembly

Start Date: 4/8/2011 Start Qty: 7.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 7.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble nut plate as per dwg

4/5/11/19 (S)

190

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 11/04/19

(S)

200

0.00



Packaging

Identify as per dwg &amp; Stock Location: 98

Memo

0.00

Packaging

11/4/19 (S) S



**Work Order ID 68216**

Friday, April 08, 2011 3:00:04 PM

Page 5

Item ID: D3955-041

Accept

Revision ID:

Item Name: Doubler Assembly

Start Date: 4/8/2011 Start Qty: 7.00

Required Date: 4/12/2011 Req'd Qty: 7.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

210

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11/4/19  
ME  
11-04-19

# Picklist Print

Monday, April 11, 2011 10:06:32 AM

Page 1

Work Order ID: 68216

Parent Item: D3955-041

Parent Item Name: Doubler Assembly



Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063 Purchased No

No

100

sf

376.0000

0.3553

2.618

3.



6061-T6 .063 Sheet



18/1-4-11

Location

Loc Qty

Loc Code

MAT021

376

113608

4

116308

36

117285

336

MS21086L3

Purchased

No

180

Each

5.0000

1



Nut Plate



113608

EP 11/04/18

Location

Loc Qty

Loc Code

ST304

5

112219

5

MS20427M3-3

Purchased

No

180

Each

1,782.000

2



Rivet



5

14

EP 11/04/18

Location

Loc Qty

Loc Code

ST318

1782

117206

1782

16

DART AEROSPACE LTD		Work Order:	18214
Description: Doubler		Part Number:	D3955-1
Inspection Dwg: D3955	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.133	*		V 1302	
Ø0.201	+0.005/-0.001	0.205	*		V	
0.750	+/-0.010	0.750	x		V	
1.000	+/-0.010	1.001	x		V	
1.250	+/-0.010	1.251	x		V	
1.375	+/-0.010	1.374	x		V	
2.38	+/-0.030	2.378	x		V	
0.613	+/-0.010	0.610	x		V	
1.313	+/-0.010	1.310	x		V	
2.063	+/-0.010	2.065	x		V	
2.563	+/-0.010	2.562	x		V	
3.063	+/-0.010	3.067	x		V	
4.813	+/-0.010	4.815	x		V	
6.313	+/-0.010	6.310	x		V	
7.313	+/-0.010	7.313	x		V	
7.813	+/-0.010	7.813	x		V	
8.199	+/-0.010	8.196	x		Pro 5.02	
8.449	+/-0.010	8.444	x		P	
9.188	+/-0.010	9.189	x		P	
9.438	+/-0.010	9.436	x		P	
10.413	+/-0.010	10.415	x		P	
10.75	+/-0.030	10.747	x		P	
0.063	+/-0.010	0.062	x		V	

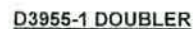
Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-4-11	Date: 11-04-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ [Signature]	[Signature]

P/O D3955-041



PL 11-0428



2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-6"  
7) WEIGHT: 0.25 lbs

0.063  
REF

INSTALL  
MS21086L3 NUT PLATE  
MS20427M3-3 RIVET, 2 PL

CSK SIDE

D3955-1  
DOUBLER

0.219

0.110

$\phi 0.201$   
REF

DE  
SC

0.219  
0.110  
0.098  
CSK 0.175 x 100  
2 PL  
0.250  
0.201  
REF  
**DETAIL A**  
SCALE 2X  
D7-1

RELEASE  
09/07/22 NND

A	NEW ISSUE		RF	09.07.21
REV		DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3955</b>  TITLE <b>SKIDTUBE TUNING KIT</b>  COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NOISE REPAIRS ON THE EXISTING CONDITION PARTS IN IT MUST BE USED FOR ANY REPAIRS OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF THE DART AEROSPACE LTD.	REV.	
DRAWN	RF			
CHECKED				
MFG. APPR.				SHEET 1 OF
APPROVED				SCALE
DE APPR.				NT
DATE	09.07.21			



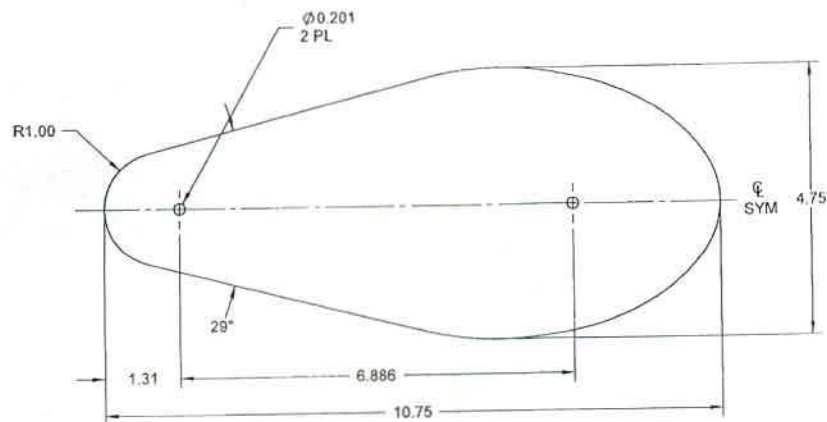


u/o 68214

RELEASE  
09/07/72

NOTES:

- |            |          |  |  |              |
|------------|----------|--|--|--------------|
| DESIGN     | DS       |  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | RF       |  | DRAWING NO.  | REV. A       |
| CHECKED    |          |  | D3955  | SHEET 2 OF 5 |
| MFG. APPR. |          |  | TITLE  | SCALE        |
| APPROVED   |          |  | <b>SKIDTUBE TUNING KIT</b>   | NTS          |
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| DATE       | 09.07.21 |  |  |              |



**D3955-X PLATE**

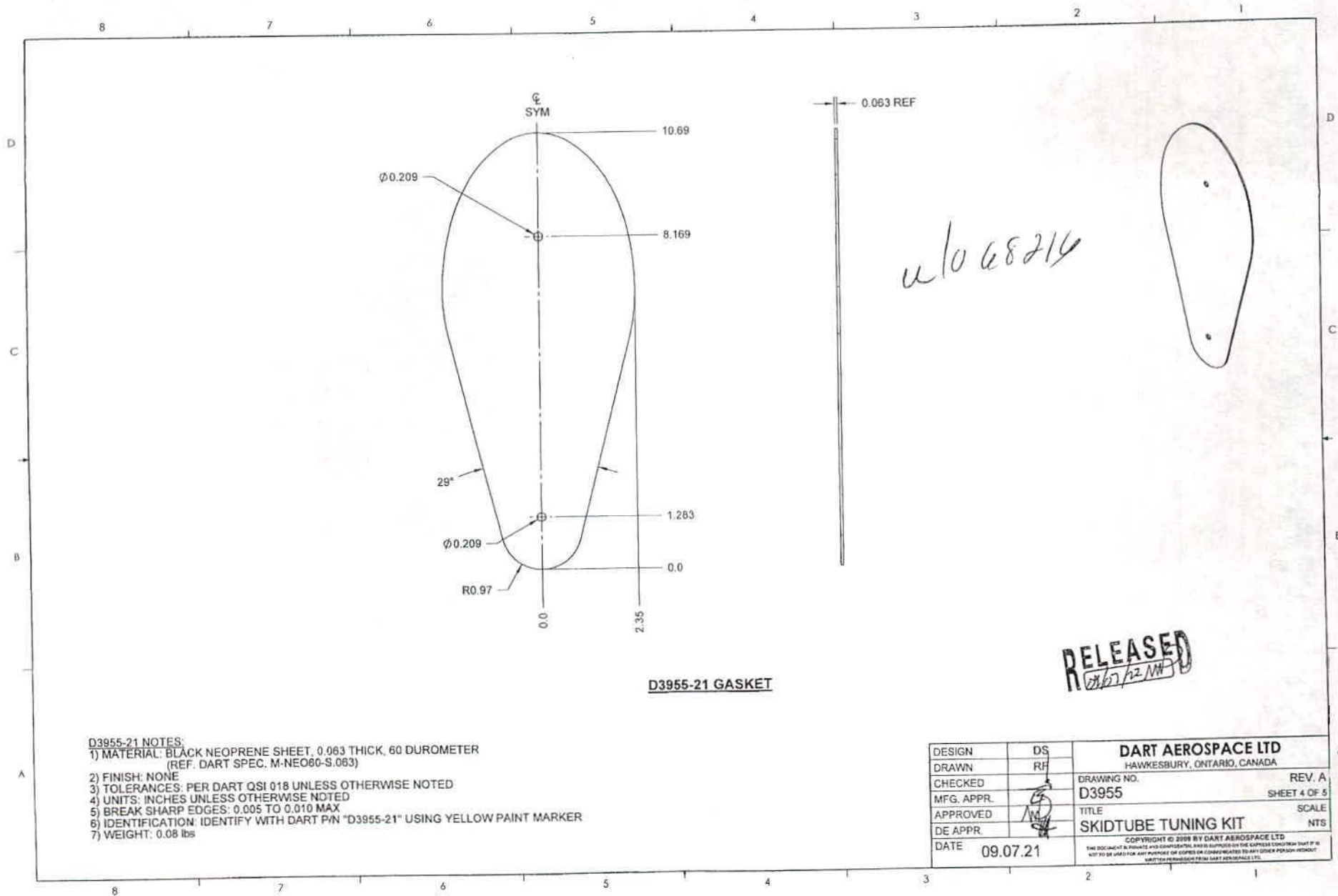
General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST/GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

**RELEASED**  
09/07/21 NPD

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 3 OF 5
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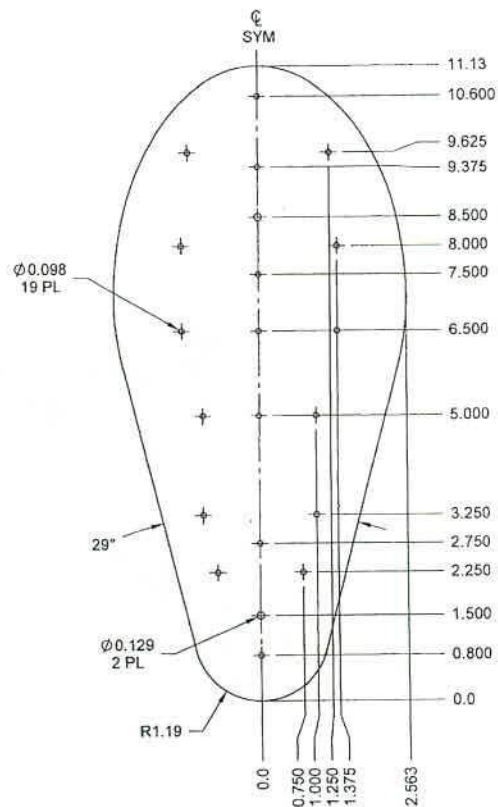
**D3955-21 GASKET**

**D3955-21 NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

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07/27/22 NH

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**D3955-23 TEMPLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.C40)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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